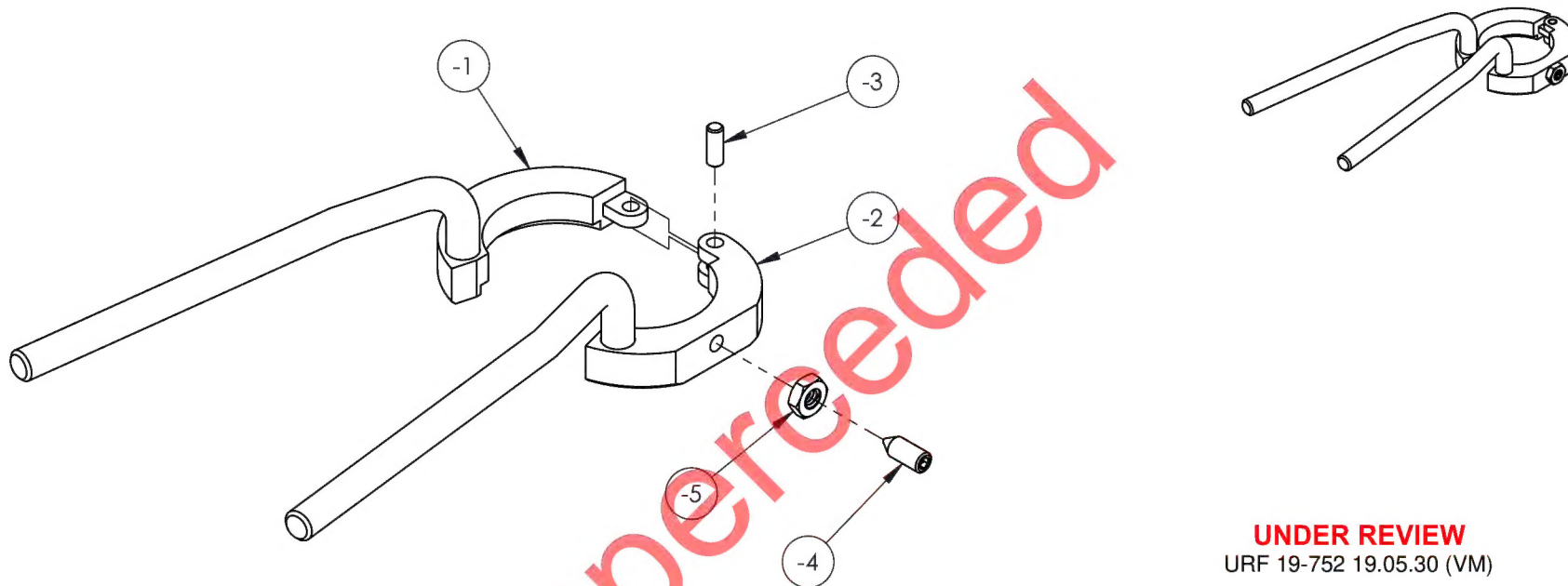


This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-1 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA". -1A CH'D MAT'L WAS 4140/4142, ADDED DIMS Ø.385±.005-.000, .040, .170±.005. CH'D DIMS WAS WAS Ø.187 PRESS FIT FOR PIN IS Ø.1869-.1874 THRU ALL (P.F. -3). WAS .160 SLIP FIT CENTRAL FOR ITEM -2A IS .160 +.000-.005 (S.F. -2A). -1B CH'D MAT'L WAS 4130 IS 4140/4142, DELETED HEAT TREAT RC 32-36, ADDED DIMS .790, (.978), (1.808), Ø.375±.005, .060. -2 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. -2A CH'D MAT'L WAS 4130 IS 4140/4142, ADDED DIMS Ø.385±.005-.000, .040, .169±.005. CH'D DIMS WAS WAS Ø.187 SLIP FIT FOR PIN IS Ø.1902-.1890 THRU ALL (S.F. -3). WAS .160 SLIP FIT CENTRAL FOR ITEM -1A IS .162 +.000-.005 (S.F. -1A). -3 ADDED B/O REF (#98381A314). -4 ADDED B/O REF (#92695A307) MODIFIED. CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. -5 ADDED B/O REF (#94846A029).	4/27/2017	DPD	JAG



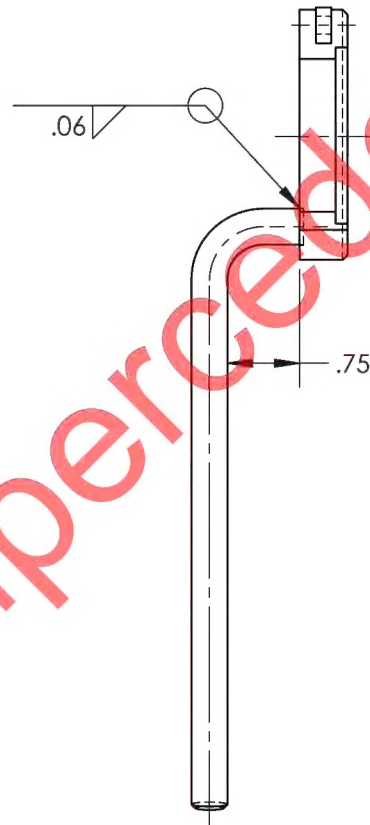
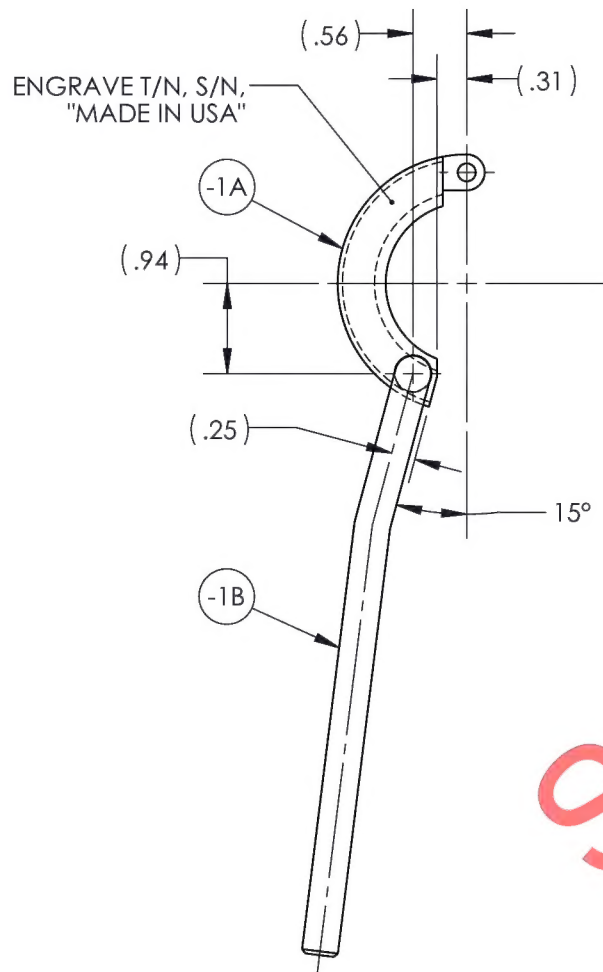
NOTE:
REF. ROLLS ROYCE T/N: 6798927.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	JAW			2
	1		-1A		JAW PART	4140/4142		3
	1		-1B		JAW PART	4140/4142		4
X			-2	1	CRIMPER JAW			5
1			-2A		JAW PART	4140/4142		6
1			-2B		JAW PART	4140/4142		7
		B/O	-3	1	DOWEL	STEEL	Ø3/16 X 1/2 (MCMaster-CARR #98381A314)	1
			-4	1	CONE POINT SET SCREW	STEEL	1/4-20 X 3/4 (MCMaster-CARR #92695A307) MODIFIED	8
		B/O	-5	1	HEX JAM NUT	STEEL	1/4-20, GRADE 5 (MCMaster-CARR #94846A029)	1
ASSY -2	ASSY -1							

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .02 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: DD 04/27/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 05/02/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/18/2017	250 SERIES
SCALE 1:2	DATE 4/27/2017
	SHEET 1 OF 8

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-1 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D. CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA".	4/27/2017	DPD	JAG



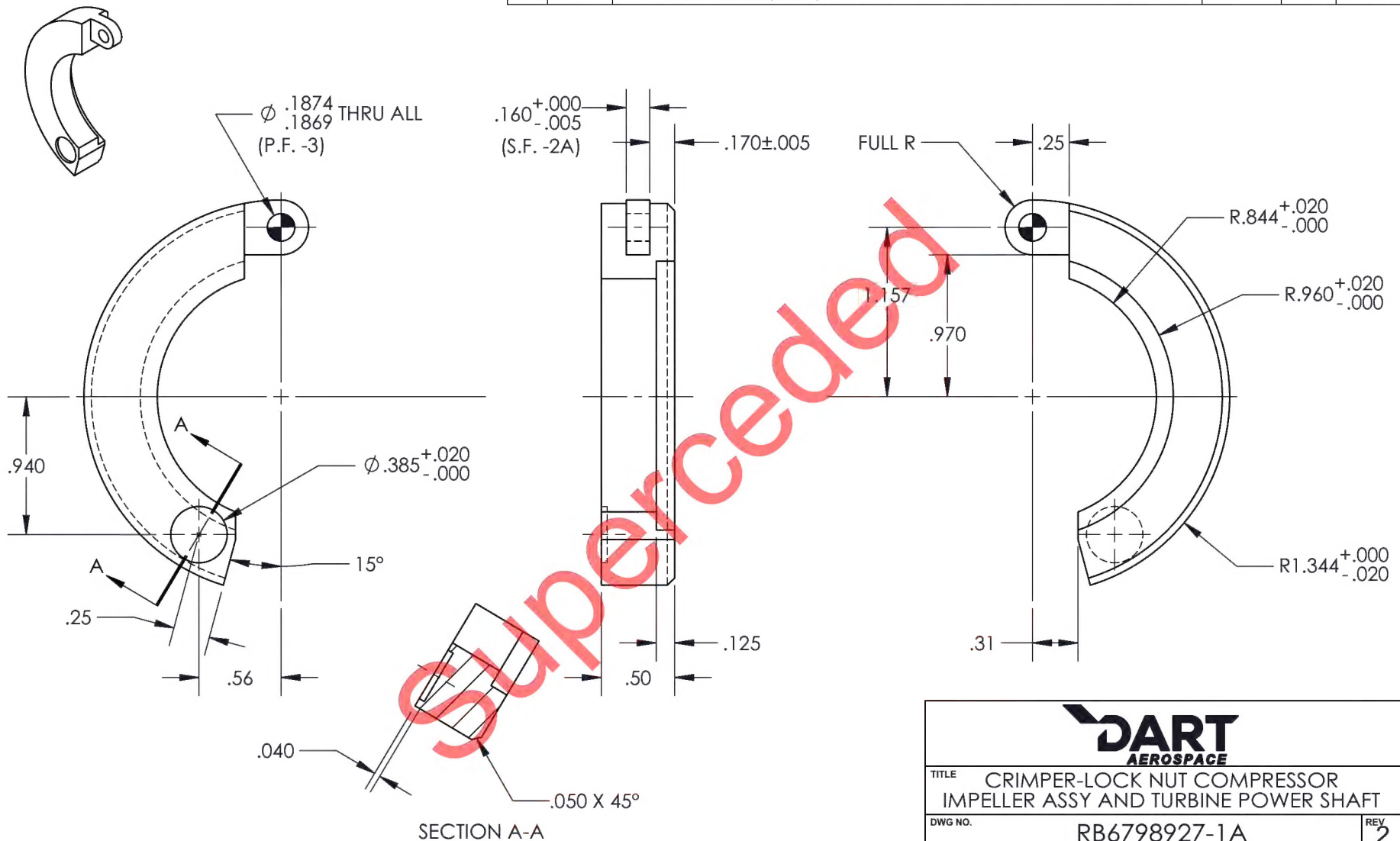
UNDER REVIEW
URF 19-752 19.05.30 (VM)

(-1)
JAW

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-1	REV 2
MAT'L TREAT FINISH BLACK OXIDE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .02 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DD 04/27/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 05/02/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 05/05/2017	USED ON MODEL
QA APPR: JL 05/10/2017	250 SERIES
APPROVED: JAG 05/18/2017	
SCALE 1:2	DATE 4/27/2017 SHEET 2 OF 8

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-1A CH'D MAT'L WAS 4130 IS 4140/4142. ADDED DIMS $\phi .385^{+.005}_{-.000}$, $\phi .40$, $.170 \pm .005$. CH'D DIMS WAS WAS $\phi .187$ PRESS FIT FOR PIN IS $\phi .1869-.1874$ THRU ALL (P.F. -3), WAS $.160$ SLIP FIT CENTRAL FOR ITEM -2A IS $.160^{+.000}_{-.005}$ (S.F. -2A).	4/27/2017	DPD	JAG



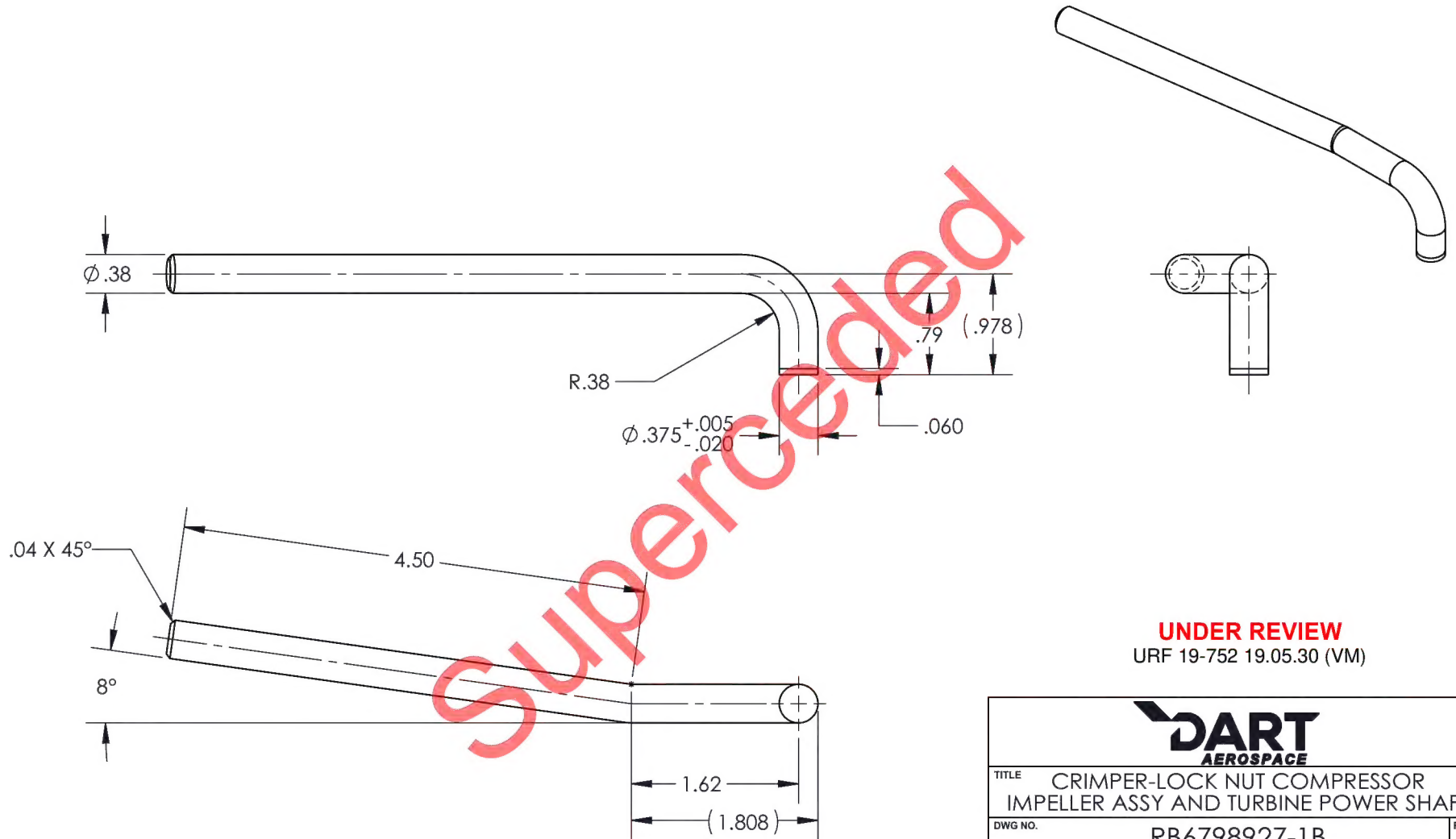
(-1A)
JAW PART

UNDER REVIEW
URF 19-752 19.05.30 (VM)

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-1A	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 32-36	.XXX $\pm .010$ FRACTIONS $\pm 1/8$
FINISH SEE -1	.XX $\pm .02$ ANGLES $\pm 1^\circ$
SPEC	.X $\pm .1$ SURFACES = 125
DRAWN BY: DD 04/27/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 05/02/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/18/2017	250 SERIES
SCALE 1:1	DATE 4/27/2017
SHEET 3 OF 8	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-1B CH'D MAT'L WAS 4130 IS 4140/4142. DELETED HEAT TREAT RC 32-36. ADDED DIMS .790, (.978), (1.808), $\phi .375 \pm .005$, .060.	4/27/2017	DPD	JAG



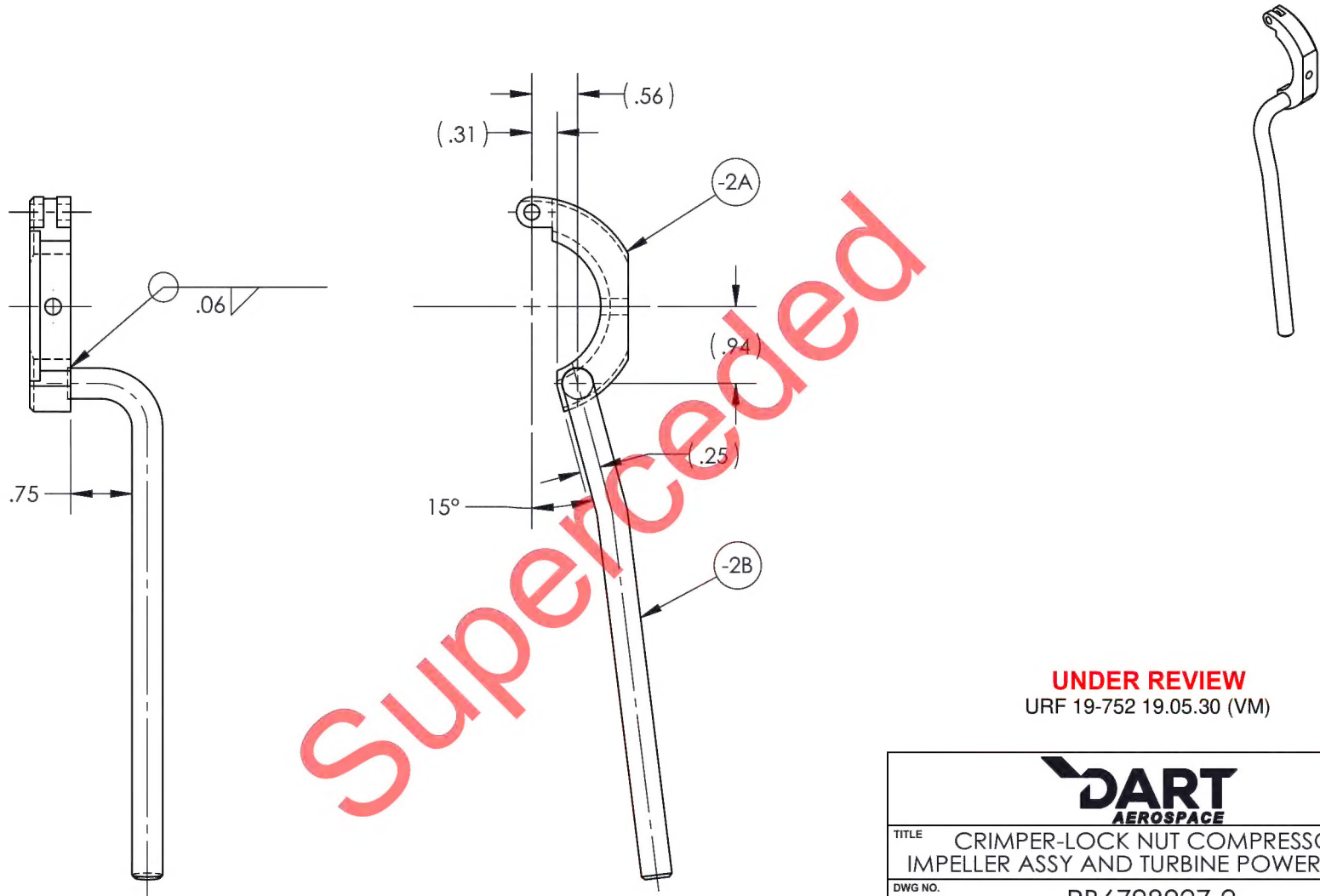
UNDER REVIEW
URF 19-752 19.05.30 (VM)

(-1B)
JAW PART

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-1B	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .02 ANGLES ± 1°
	.X ± .1 SURFACES = 125
DRAWN BY: DD 04/27/2017	1. BREAK ALL SHARP EDGES
CHECKED: RJC 05/02/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/05/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/10/2017	AFTER PLATING
APPROVED: JAG 05/18/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 2:3	DATE 4/27/2017
	SHEET 4 OF 8

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-2 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D.	4/27/2017	DPD	JAG



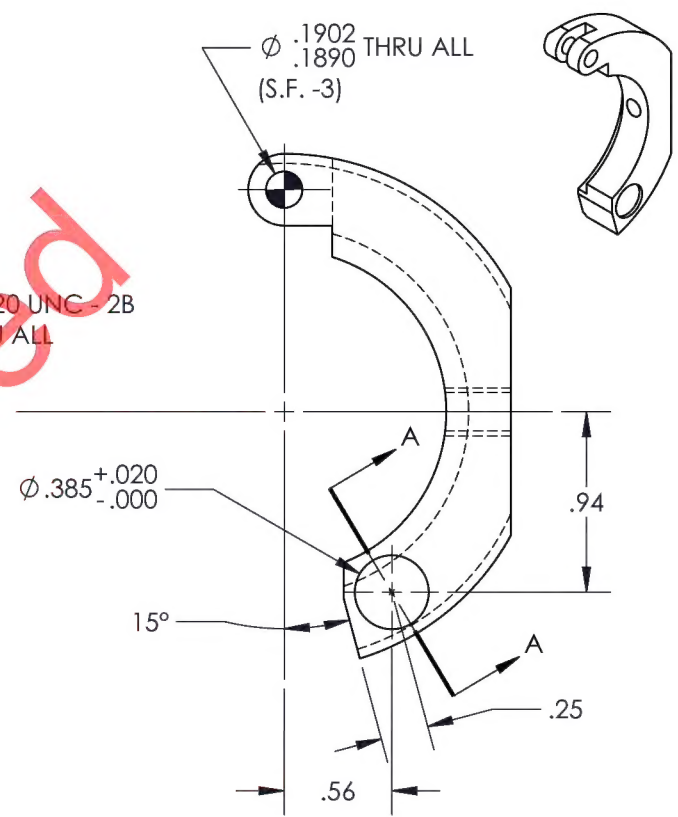
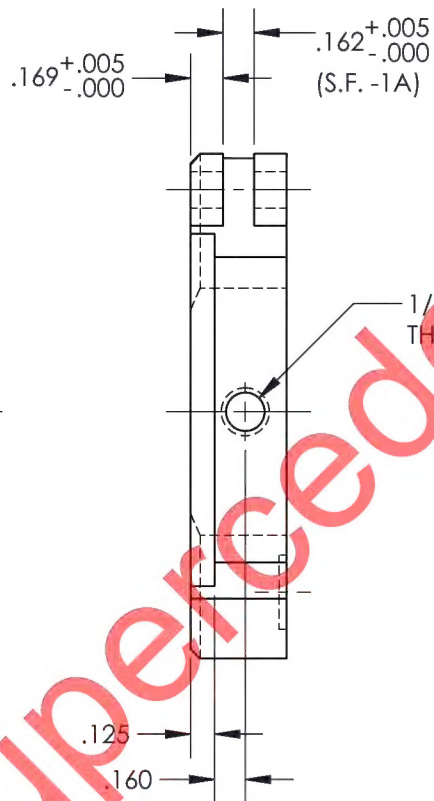
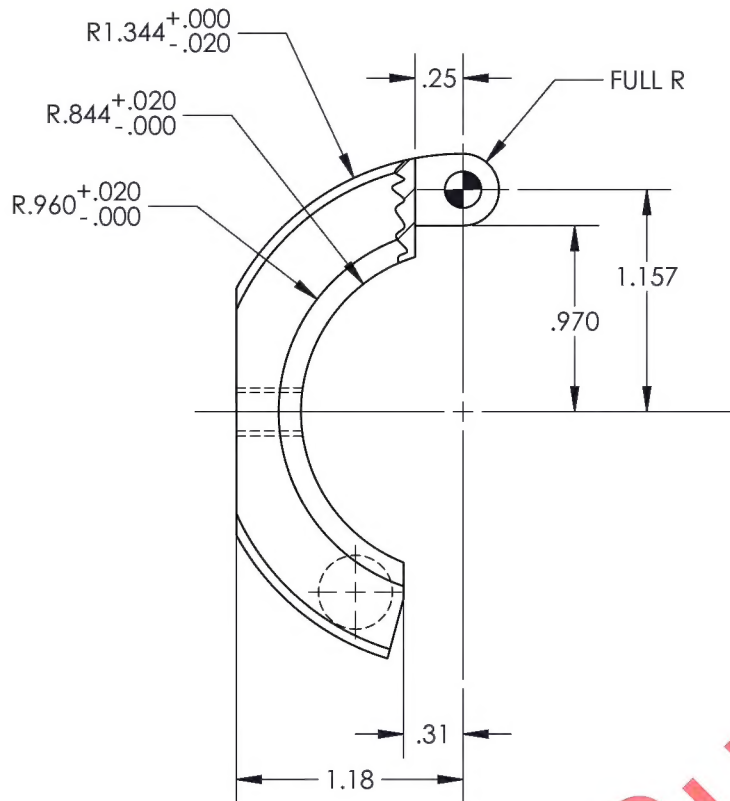
UNDER REVIEW
URF 19-752 19.05.30 (VM)

(-2)
CRIMPER JAW

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-2	REV 2
MAT'L TREAT FINISH BLACK OXIDE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .02 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DD 04/27/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 05/02/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 05/05/2017	USED ON MODEL
QA APPR: JL 05/10/2017	250 SERIES
APPROVED: JAG 05/18/2017	
SCALE 1:2	DATE 4/27/2017 SHEET 5 OF 8

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-2A CH'D MAT'L WAS 4130 IS 4140/4142. ADDED DIMS $\phi .385^{+.005}_{-.000}$, $.040$, $.169 \pm .005$. CH'D DIMS WAS WAS $\phi .187$ SLIP FIT FOR PIN IS $\phi .1902-.1890$ THRU ALL (S.F. -3), WAS $.160$ SLIP FIT CENTRAL FOR ITEM -1A IS $.162^{+.000}_{-.005}$ (S.F. -1A).	4/27/2017	DPD	JAG



Supercritical

UNDER REVIEW
URF 19-752 19.05.30 (VM)

(-2A)

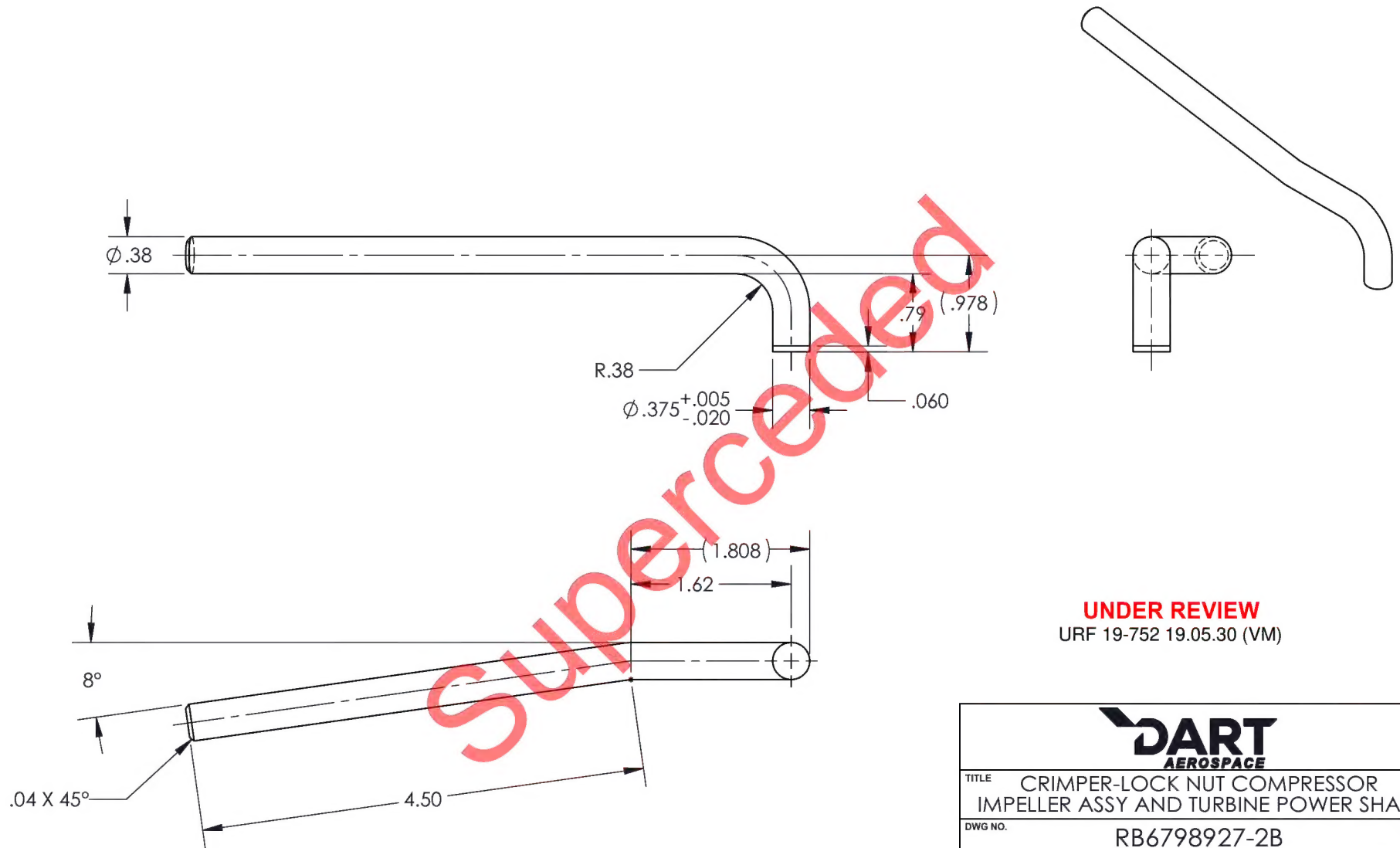
JAW PART

SECTION A-A

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-2A	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 32-36	DIMENSIONS ARE IN INCHES
FINISH SEE -2	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .02 ANGLES ± 1°
	.X ± .1 SURFACES = 125
DRAWN BY: DD 04/27/2017	1. BREAK ALL SHARP EDGES
CHECKED: RJC 05/02/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: JL 05/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 05/18/2017	USED ON MODEL
SCALE 1:1	250 SERIES
DATE 4/27/2017	SHEET 6 OF 8

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-2B CH'D MAT'L WAS 4130 IS 4140/4142. DELETED HEAT TREAT RC 32-36. ADDED DIMS .790, (.978), (1.808), $\phi .375 \pm .005$, .060.	4/27/2017	DPD	JAG



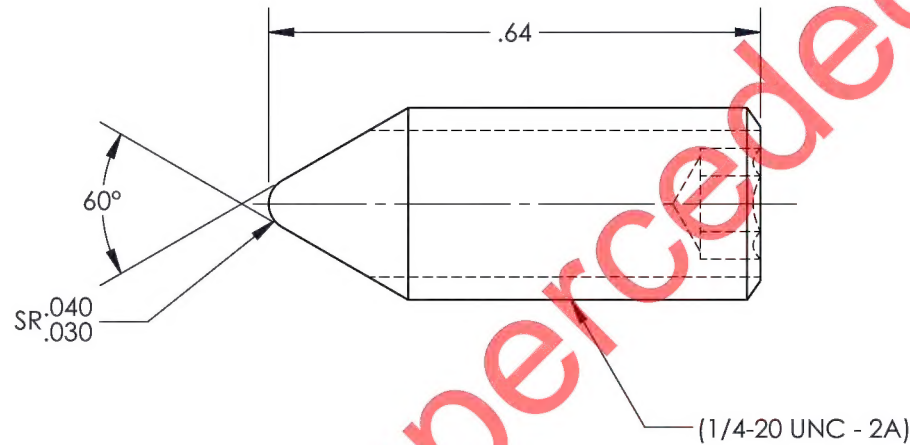
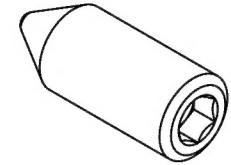
UNDER REVIEW
URF 19-752 19.05.30 (VM)

(-2B)
JAW PART

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-2B	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX \pm .010 FRACTIONS \pm 1/8
FINISH SEE -2	.XX \pm .02 ANGLES \pm 1°
SPEC	.X \pm .1 SURFACES = 125° ✓
DRAWN BY: DD 04/27/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 05/02/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/18/2017	250 SERIES
SCALE 2:3	DATE 4/27/2017
SHEET 7 OF 8	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-4 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D.	4/27/2017	DPD	JAG



UNDER REVIEW
URF 19-752 19.05.30 (VM)

(-4)

CONE POINT SET SCREW

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-4	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .010 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .02 ANGLES ± 1°
DRAWN BY: DD 04/27/2017	.X ± .1 SURFACES = 125/✓
CHECKED: RJC 05/02/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 05/05/2017	.015 x 45° OR .015R
QA APPR: JL 05/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 05/18/2017	AFTER PLATING
SCALE 4:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 4/27/2017	USED ON MODEL
SHEET 8 OF 8	